

Work Order ID 70869

Thursday, June 16, 2011 12:43:40 PM

Page 1

Item ID: D3022-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Seat Pan

Start Date: 6/16/2011 Start Qty: 1.00

Cust Item ID:

Required Date: 6/24/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3022

Rev B

100

0.00



Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3022

Dwg Rev: B

Prog Rev: B

*** grind direction along 31.700" ***

2-Debur if necessary

B 11-6-16

3

110

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

B 11-6-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 70869

Thursday, June 16, 2011 12:43:40 PM



Page 2

Item ID: D3022-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Seat Pan

Start Date: 6/16/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/24/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

8/16/17

+3

Quality Control

130

Bend as per dwg

0.00



Brake NC

NC BRAKE

Memo

0.00

5/16/17

3

Brake NC

1- Bend as per Dwg D3022

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

8/16/17

+3

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 70869

Thursday, June 16, 2011 12:43:40 PM



Page 3

Item ID: D3022-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Seat Pan

Start Date: 6/16/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/24/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Transfer drill Seat Pan From Frame
Transfer drill in D3022-1 using D3017-041

2-Deburr

11-8-3 (X1)

160

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

Sulosby

(4)

170

0.00



Chemical Conversion Coat per QSI005 4.1

HandFinish

Memo

0.00

Hand Finishing

1 of 1108104

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 70869

Thursday, June 16, 2011 12:43:40 PM



Page 4

Item ID: D3022-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Seat Pan

Start Date: 6/16/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/24/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



1117338

Powdercoat

Memo

0.00

Powder Coating

START TIME: 10:15am
OVEN TEMPERATURE: 320°F
FINISH TIME: 10:45am

1 6 M 11/17/08

190

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1X 6 M 11/17/08

200

Identify as per dwg & Stock Location: 6 A

0.00



Packaging

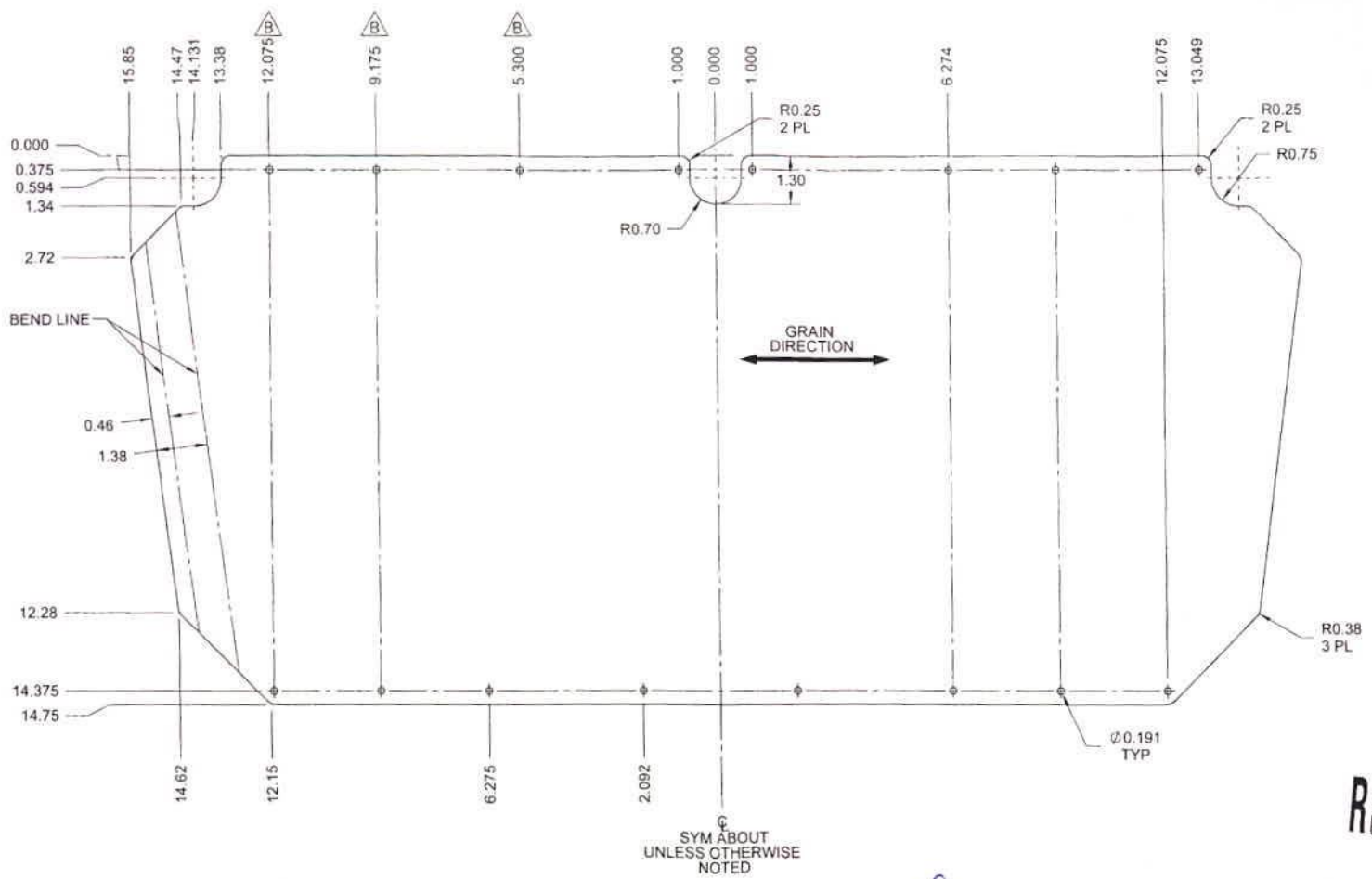
Memo

0.00

Packaging

w/o
70903

3/10/08 10 @



RELEASED
08/12/15

- NOTES:
- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.032 THICK
PER AMS-QQ-A-250/4 OR AMS 4037
REF DART SPEC M2024T3S.032
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.36 lbs

D3022-1F SEAT PAN

Handwritten signature/initials

DESIGN	GP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO. D3022	REV. B
MFG. APPR.			SHEET 3 OF 3
APPROVED		TITLE SEAT PAN	SCALE NTS
DE APPR.		COPYRIGHT © 2001 BY DART AEROSPACE LTD	
DATE	08.11.27	THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT NOT TO BE USED FOR ANY PURPOSE OR FOR REPRODUCTION IN ANY FORM OR BY ANY MEANS WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

Order ID 70869

, June 16, 2011 12:43:40 PM



Page 5

D: D3022-I

Accept



Setup Start



Division ID:

Stop



Item Name: Seat Pan

Start Date: 6/16/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/24/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

CK 11/08/10

11-08-10